

Classifications								
EN ISO 18274								
S Ni Z (NiCr36Fe15Nb0.8)								
Characteristics and field of use								
UTP A 3545 Nb is suitable for joining and surfacing on identical and similar high-heat-resistant cast alloys (centrifugal- and mould cast parts), such as GX-45NiCrNbSiTi45 35. The main application field is tubes and cast parts of reformer and pyrolysis ovens.								
Properties of the weld metal								
The weld deposit is applicable in low-sulphur, carbon-enriching atmosphere up to 1,175°C.								
Typical analysis in %								
C	Si	Mn	Cr	Ni	Nb	Ti	Zr	Fe
0.45	1.5	0.8	35.0	45.0	0.8	0.1	0.05	balance
Mechanical properties of the weld metal								
Yield strength $R_{p0,2}$				Tensile strength R_m				
MPa				MPa				
450				550				
Welding instruction								
Clean weld area thoroughly. No pre-heating or post weld heat treatment required. Keep heat input as low as possible and interpass temperature of max. 150°C.								
Rod diameter x length [mm]	Current type			Shielding gas (EN ISO 14175)				
2.0 x 1000	DC (-)			I 1				
2.4 x 1000	DC (-)			I 1				
3.2 x 1000	DC (-)			I 1				